Monday, 1/8/2007 11:08:43 AM User: Kim Johnston **Process Sheet** : BUSHING Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : 30198 Job Number : 10175 **Estimate Number** : D2570 **Part Number** P.O. Number S.O. No. : 1/10 : D2570 REV A : 1/8/2007 **Drawing Number** This Issue Prsht Rev. **Project Number** : N/A : WIA Type : MACHINED PARTS **Drawing Revision** First Issue : 29776 Material **Previous Run** 500 Um: : 1/20/2007 Each **Due Date** Qty: Written By Checked & Approved By Re-format; Removed finishing; Material change K Comment J **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: ,M303R0750 303 Round Bar .75" 1.0 scrap a parts 10" No good. M 103503

scrap 3 parts of 10" No good M1023.

Strozloz Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <u>4103503</u> 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPEC PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock-

Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANG	ES				
DATE	STEP	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/03/0
		2	QA: N/C Closed:	Date:

NCR:	-	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
						_			

NOTE: Date & initial all entries

Date: User:

Monday, 1/8/2007 11:08:43 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 30198

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	1 4 1	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NC	R: Yes	No DQ	A :	_ Date: _	

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	 	Varification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approva QC Inspecto		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30198
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			opodion	
0.800	+/-0.010	, 804	1			
0.060	+/-0.005	.063	/			
R0.010	+0.010/-0.000	.010				
Ø0.425	+0.000/-0.002	y GPi,	1			
Ø0.257	+0.005/-0.000	,260	/			
Ø0.750	+/-0.010	.745	✓			
0.030 x 20°	+/-0.010	,030 y 20°	\sim			
					_	

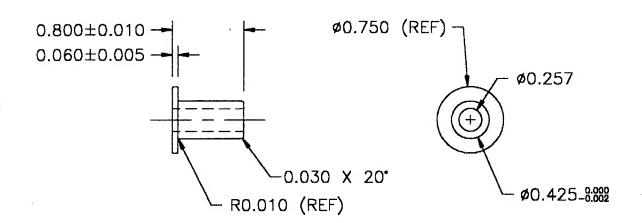
Measured by:	Audited by:	MS.	Prototype Approval:	N/A
Date: 67/02/27	Date:	07/02/22	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF LA	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	. 4



DESIGN	DRAWN BY	DART VICTORIA	AEROSPACE LTE)		
CHECKED	APPROVED	DRAWING NO.		F	₹EV.	A
4	MS.	D2570	SHEE	ET 1	OF	1
DATE		TILE			SCA	E
 96:09:16		BUSHING				:1

RELEASED



BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 - 0.75 DIA STOCK

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER